

TITLE

HIGHLY-RESILIENT THERMOPLASTIC ELASTOMER COMPOSITIONS

BACKGROUND OF THE INVENTION

This application is a continuation in part of U.S. Patent
5 Application 09//422,122, filed October 21, 1999, which claims the benefit
of U.S. Provisional Applications Nos. 60/105,065 and 60/105,232, filed
October 21, 1998 and Nos. 60/105,193 and 60/105,181, filed October 22,
1998.

Field of the Invention

10 The invention relates to highly-resilient thermoplastic
elastomer compositions, their manufacture and their use as a substitute
for thermoset and thermoplastic materials, particularly in the manufacture
of one-, two-, three-piece, and multi-layered golf balls, particularly to
thermoplastic polymer blend compositions useful therein. These
15 compositions are also useful as foamed materials in footwear and other
sport balls such as softballs.

Description of Related Art

Typically, thermoset materials such as polybutadiene rubber,
cross-linked EVA, cross-linked SBS, and cross-linked urethanes have
20 been used in applications where properties such as resilience, durability,
and low hardness are needed. For example, polybutadiene rubber has
traditionally been used in the cores and centers of golf balls.

There currently exist several types of premium golf balls,
particularly three-piece balls, two-piece balls and multi-layered balls.
25 "Three-piece" balls typically have a spherical molded center, having an
elastomeric thread-like material wound around it, covered with either a
thermoplastic or thermoset material. "Two-piece" balls typically have a
spherical molded core covered with a thermoplastic material. "Multi-
layered" balls typically have a core and one or more intermediate layers or
30 mantles between the core and a cover.

The material used to mold the three-piece centers and the
two-piece and multi-layer cores has traditionally been a thermoset rubber
such as polybutadiene rubber. There are, however, major disadvantages

in using thermoset rubbers such as the inability to recycle scrap materials and the need for complex multi-step manufacturing processes. There has been only limited success in attempts to replace the thermoset materials with more-easily-processed thermoplastic materials, the scrap of which
5 can be recycled.

Also, three-piece balls, two-piece balls, and multi-layered balls are by their very nature more complicated and costly to manufacture than the long sought after one-piece golf ball. Attempts to make a premium one-piece ball have heretofore not been successful. Limited-
10 flight range balls, however, have been produced from thermoset rubber and from certain thermoplastic material as set forth in U.S. Patent No. 5,155,157.

U.K. Patent Application 2,164,342A describes one attempt to replace centers and cores and achieve a one-piece golf ball. It teaches
15 moldable compositions comprising ionic copolymers (or potentially ionizable acid copolymers) blended with certain thermoplastic materials such as a polyether block copolyamide, polyether block copolyester and the like. Those compositions are said to be useful as three-piece centers, two-piece cores and one-piece solid golf balls, but they lack properties
20 such as durability. Also, U.S. 5,155,157 describes a thermoplastic material for cores, centers and one-piece balls. The resins described in this patent can be molded into golf ball parts but the resulting balls are too hard and not resilient enough to perform as a premium golf ball and they are probably too expensive.

There still exists the need for a thermoplastic material that is
25 resilient and durable enough with a low enough hardness or compression to be useful as a three-piece center, two-piece core, a one-piece golf ball, and in cores and mantles in a multi-layered golf ball in premium golf balls. Particularly, there is a need for such a material that is not too expensive.

30 **SUMMARY OF THE INVENTION**

The subject invention provides thermoplastic compositions having high resilience, methods of manufacturing such compositions, and

products made therefrom, such as components of one-, two- and three-piece golf balls or multi-layered golf balls, sport balls and footwear.

More specifically, the thermoplastic composition of this invention is a composition comprising (a) an ethylene, C_{3-8} α,β -ethylenically unsaturated carboxylic acid copolymer; (b) a high molecular weight, monomeric organic acid or salt thereof; (c) a thermoplastic elastomer polymer selected from copolyetheresters, copolyetheramides, block styrene polydiene thermoplastic elastomers, elastomeric polyolefins, and thermoplastic polyurethanes; (d) a cation source; and (e) a filler (optionally present). Preferably, component (b) is present at about 10 to about 45 weight percent (wt.%) of (a), (b) and (c) provided that component (b) does not exceed 50 wt.% of (a) plus (b); component (c) is present at about 1 to about 35 wt.% of (a), (b) and (c); and (d) is present at a level sufficient to neutralize 80 to 110 (preferably 90 to 110, or 95 to 110) percent of the combined acid content of (a) and (b). Component (e) is optionally added as needed to adjust density in a preferred range of up to 60 parts per 100 parts by weight of components (a) through (d).

The present invention further provides golf ball components, particularly cores, centers, and mantles (one or more layers between the cover and the central portion of ball) and one piece golfballs, comprising the compositions of (a) an ethylene, C_{3-8} α,β -ethylenically unsaturated carboxylic acid copolymer; (b) about 10 to about 45 weight percent (wt.%) of (a), (b) and (c) provided that component (b) does not exceed 50 wt.% of (a) plus (b) of a high molecular weight, monomeric organic acid or salt thereof; (c) about 1 to about 35 wt.% of (a), (b) and (c) of a thermoplastic elastomer polymer selected from copolyetheresters, copolyetheramides, block styrene polydiene thermoplastic elastomers, elastomeric polyolefins, and thermoplastic polyurethanes; (d) a cation source present at a level sufficient to neutralize 50 to 110 (preferably 80 to 110, 90 to 110, or 95 to 110) percent of the combined acid content of (a) and (b); and optionally (e) a filler in a preferred range of up to 60 parts per 100 parts by weight of components (a) through (d).

Preferable ranges, particularly for use in golf ball components, for components (a) through (e) are as set forth in the following table (Component (a) is always present and component (d), in each case, is present at a level sufficient to neutralize 50 to 110 percent or the combined acid content of (a) and (b). Percentages of (b) and (c) are the approximate weight percentages based on the total weight of (a) through (c). Component (e) is reported as parts per hundred parts of by weight of (a) through (d). Component (b) should be within the ranges set forth provided that component (b) does not exceed 50 wt.% of (a) plus (b)).

	(b)	(c)	(e)
1	5-40%	1-35%	0-60 parts
2	5-40%	1-35%	Sufficient to raise density to 1.14 – 1.8 gms/cc
3	10-30%	1-30%	Sufficient to raise density to 1.14 – 1.22 gms/cc
4	10-30%	1-30%	15-25 parts
5	15-30%	1-25%	15-35 parts
6	18-22%	1-15%	18-22 parts
7	5-10%	10-35%	Sufficient to raise density to 1.8 gms/cc
8	5-10%	10-35%	40-60 parts
9	5-10%	25-35%	40-55 parts
10	5-10%	28-35%	50-55 parts
11	5-30%	1-35%	0-60 parts

One embodiment of a product using such composition is a one-piece golf ball comprising (a) ethylene acid copolymer, (b) 10-45 wt.% high molecular weight, monomeric organic acid or salt thereof provided that component (b) does not exceed 50 wt.% of (a) plus (b), (c) 1-30 wt.% thermoplastic, (d) sufficient cation to neutralize 50 to 110 percent of the acid in the acid copolymer and organic acid, and (e) sufficient filler, preferably 15-25 parts per hundred weight of polymer (a) – (d), to adjust density of ball to 1.14 grams/cubic centimeter (gm/cc). Preferably the filler has a density of about 4 gm/cc or greater.

Another embodiment of such a product is a two-piece golf ball having a core and a cover. The core is made of a composition comprising (a) ethylene acid copolymer, (b) 10-45 wt.% high molecular weight, monomeric organic acid or salt thereof provided that component (b) does not exceed 50 wt.% of (a) plus (b), (c) 1-30 wt.% thermoplastic elastomer, (d) sufficient cation to neutralize 50 to 110 percent of the acid in the acid copolymer and organic acid, and (e) sufficient filler, preferably 15-35 parts per hundred parts by weight of (a) through (d), to adjust the density of the core to about 1.18 –1.22 gm/cc. The amount of filler can be adjusted to produce a core with a density varying from the 1.18 gm/cc depending on the diameter of the core and the thickness and composition of the cover to produce a golf ball meeting the weight limits (45 grams) set by the professional golfers' governing authority (e.g. U.S. Golf Association). Preferably the filler has a density of about 4 gm/cc or greater.

Another embodiment is a three-piece golf ball having a center, elastomeric wrapping and a cover. The center is made of a composition comprising (a) ethylene acid copolymer, (b) 5-35 wt.% high molecular weight, monomeric organic acid or salt thereof provided that component (b) does not exceed 50 wt.% of (a) plus (b), (c) 10-35 wt.% thermoplastic elastomer, (d) sufficient cation to neutralize 50 to 110 percent of the acid in the acid copolymer and organic acid, and (e) sufficient filler, preferably 40-60 parts per hundred parts by weight (a) through (d), to adjust the density of the center to about 1.8 gm/cc. As with the two-piece ball, the amount of filler can be adjusted depending on the size, thickness and composition of the other ball components to produce a golf ball of the desired weight (e.g. about 45 grams).

Another embodiment is a multi-layer golf ball having a core and a cover with one or more intermediate layers or mantles between the core and the cover. Sometimes the "core" is referred to in the industry and in this application as a "center." Both the core and the mantle(s) can comprise the composition of this invention. The amount of filler employed in the core and mantle(s) can be varied from 0 to about 60 parts per

hundred parts by weight of (a) through (d) depending on the size (thickness) of the components and the desired location of the weight in the ball, provided that the final ball meets the required weight limits. The filler can be used in the core and not in the mantle, in the mantle and not in the core, or in both. Thus, the mantle or the core can comprise (a) ethylene acid copolymer, (b) about 5-30 wt.% high molecular weight, monomeric organic acid or salt thereof provided that component (b) does not exceed 50 wt.% of (a) plus (b), (c) 1-35 wt.% thermoplastic elastomer, (d) sufficient cation to neutralize 50 to 110 percent of the acid in the acid copolymer and organic acid, and (e) sufficient filler, if needed, to adjust the density to the desired level.

As will be appreciated by one skilled in the art, the present invention allows unique golf ball constructions, which are also the subject of this invention. For example, the weight of the golf ball can be distributed differently than in current golf balls. It is possible to have more weight near the surface of the ball or midway between the center and the surface with a lower density center. It is also possible with the thermoplastic composition of this invention as the core to mold a pattern such as dimples into the core. By doing so, it is possible to obtain a golf ball having a cover with a uniform thickness throughout in contrast to presently available golf balls which have covers that are thinner in the area of the dimples.

BRIEF DESCRIPTION OF FIGURES

Figure 1 is a two-dimensional plot of Coefficients of Restitution for one-piece compression-molded golf balls of this invention as determined in an ECHIP study.

Figure 2 is a three-dimensional plot of the same information presented in Figure 1.

Figure 3 is a two-dimensional plot of Atti Compression of one-piece compression-molded golf balls of this invention as determined in an ECHIP study.

Figure 4 is a three-dimensional plot of the same information presented in Figure 3.

DETAILED DESCRIPTION OF THE INVENTION

Because the species and relative ratios of the components used in the practice of the subject invention vary somewhat, particularly when considered based on the type of golf ball desired (i.e., one-piece, two-piece, three-piece or multi-layered ball), it is useful to first consider the components themselves.

All patents or publications set forth herein are fully incorporated by reference.

COMPONENT DESCRIPTIONS

In this disclosure, the term copolymer is used to refer to polymers containing two or more monomers. The term bipolymer or terpolymer refers to polymers containing only two or three monomers respectively. The phrase 'copolymer of various monomers' means a copolymer whose units are derived from the various monomers.

Thermoplastic Elastomer Polymer

The thermoplastic elastomer polymer component of the invention is selected from copolyetheresters, copolyetheramides, elastomeric polyolefins, styrene diene block copolymers and thermoplastic polyurethanes, these classes of polymers being well known in the art.

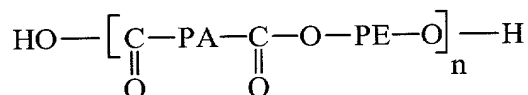
The copolyetheresters are discussed in detail in patents such as U.S. Patents 3,651,014; 3,766,146; and 3,763,109. They are comprised of a multiplicity of recurring long chain units and short chain units joined head-to-tail through ester linkages, the long chain units being represented by the formula

$$\text{---OGO---}\overset{\text{O}}{\parallel}\text{C}\overset{\text{O}}{\parallel}\text{RC---}$$
 and the short chain units being represented by the formula

$$\text{---ODO---}\overset{\text{O}}{\parallel}\text{C}\overset{\text{O}}{\parallel}\text{RC---}$$
 where G is a divalent radical remaining after the removal of terminal hydroxyl groups from a poly (alkylene oxide) glycol having a molecular weight of about 400-6000 and a carbon to oxygen ratio of about 2.0-4.3; R is a divalent radical remaining after removal of hydroxyl groups from a dicarboxylic acid having a molecular weight less

than about 300; and D is a divalent radical remaining after removal of hydroxyl groups from a diol having a molecular weight less than about 250; provided said short chain ester units amount to about 15-95 percent by weight of said copolyetherester. The preferred copolyetherester polymers are those where the polyether segment is obtained by polymerization of tetrahydrofuran and the polyester segment is obtained by polymerization of tetramethylene glycol and phthalic acid. Of course, the more polyether units incorporated into the copolyetherester, the softer the polymer. For purposes of the invention, the molar ether:ester ratio can vary from 90:10 to 10:90, preferably 80:20 to 60:40; and the shore D hardness is less than 70, preferably less than about 40.

The copolyetheramides are also well known in the art as described in U.S. 4,331,786, for example. They are comprised of a linear and regular chain of rigid polyamide segments and flexible polyether segments, as represented by the general



formula

wherein PA is a linear

saturated aliphatic polyamide sequence formed from a lactam or aminoacid having a hydrocarbon chain containing 4 to 14 carbon atoms or from an aliphatic C₆-C₉ diamine, in the presence of a chain-limiting aliphatic carboxylic diacid having 4-20 carbon atoms; said polyamide having an average molecular weight between 300 and 15,000; and PE is a polyoxyalkylene sequence formed from linear or branched aliphatic polyoxyalkylene glycols, mixtures thereof or copolyethers derived therefrom said polyoxyalkylene glycols having a molecular weight of less than or equal to 6000 and n indicates a sufficient number of repeating units so that said polyetheramide copolymer has an intrinsic viscosity of from about 0.8 to about 2.05. The preparation of these polyetheramides comprises the step of reacting a dicarboxylic polyamide, the COOH groups of which are located at the chain ends, with a polyoxyalkylene glycol hydroxylated at the chain ends, in the presence of a catalyst such as a tetra-alkyl ortho-titanate having the general formula Ti(OR)₄, wherein R is a linear branched aliphatic hydrocarbon radical having 1 to 24 carbon

atoms. Again, the more polyether units incorporated into the copolyetheramide, the softer the polymer. The ether:amide ratios are as described above for the ether:ester ratios, as is the shore D hardness.

5 The elastomeric polyolefins are polymers composed of ethylene and higher primary olefins such as propylene, hexene, octene and optionally 1,4 - hexadiene and or ethylidene norbornene or norbornadiene. The elastomeric polyolefins can be functionalized with maleic anhydride.

10 Thermoplastic polyurethanes are linear or slightly chain branched polymers consisting of hard blocks and soft elastomeric blocks. They are produced by reacting soft hydroxy terminated elastomeric polyethers or polyesters with diisocyanates such as methylene diisocyanate (MDI) or toluene diisocyanate(TDI). These polymers can be chain extended with glycols, diamines, diacids, or amino alcohols. The reaction products
15 of the isocyanates and the alcohols are called urethanes and these blocks are relatively hard and high melting. These hard high melting blocks are responsible for the thermoplastic nature of the polyurethanes.

Block styrene diene copolymers are composed of polystyrene units and polydiene units. The polydiene units are derived from
20 polybutadiene, polyisoprene units or copolymers of these two. In the case of the copolymer it is possible to hydrogenate the polyolefin to give a saturated rubbery backbone segments. These materials are usually referred to as SBS, SIS or SEBS thermoplastic elastomers and they can also be functionalized with maleic anhydride.

25 High-molecular-weight, monomeric organic acids and their salts

The high-molecular weight, monomeric saturated or unsaturated organic acids of the present invention are fatty acids, particularly stearic, behenic, erucic, oleic, and linoleic acids. Preferably the organic acids are mono-functional. The salts of organic acid of the
30 present invention comprise the salts, particularly the barium, lithium, sodium, zinc, bismuth, chromium, cobalt, copper, potassium, strontium, titanium, tungsten, magnesium or calcium salts, of the fatty acids. Preferably, the fatty acid salt is selected to have the lowest volatility. It is

chosen so as to maximize COR while minimizing Atti Compression, which has often been called "PGA Compression" in the art.

Ethylene Acid Copolymers and Ionomers

5 The acid copolymers of this invention are prepared from 'direct' acid copolymers, that is to say copolymers polymerized by adding all monomers simultaneous, as distinct from a graft copolymer, where a monomer or other unit is grafted onto an existing polymer, often by a subsequent free radical reaction. Methods of preparing ionomers are well known, and are described in U.S. Patent No. 3,264,272 (Rees). Method of
10 preparing the acid copolymers on which the ionomers are based is described in U.S. Patent No. 4,351,931.

The acid copolymers preferably are alpha olefin, particularly ethylene, C₃₋₈ α,β ethylenically unsaturated carboxylic acid, particularly acylic and methacrylic acid, copolymers. They may also contain a third
15 softening monomer such as an alkyl acrylate or methacrylate. The ethylene acid copolymers can be described as an E/X/Y copolymers where E is ethylene, X is the α,β ethylenically unsaturated carboxylic acid, particularly acylic and methacrylic acid, and Y is a softening comonomer such as a C₁ TO C₈ alkyl acrylate or methacrylate ester. X is preferably
20 present in 4-35 (preferably 6-35, most preferably 8-20) weight percent (wt.%) of the polymer, and Y, when present, is preferably present in up to 50 (preferably 5-25, most preferably 11-23) weight percent of the polymer.

Specific acid-containing ethylene copolymers include, ethylene/acrylic acid/n-butyl acrylate, ethylene/methacrylic acid/n-butyl
25 acrylate, ethylene/methacrylic acid/iso-butyl acrylate, ethylene/acrylic acid/iso-butyl acrylate, ethylene/methacrylic acid/n-butyl methacrylate, ethylene/acrylic acid/methyl methacrylate, ethylene/acrylic acid/methyl acrylate, ethylene/ methacrylic acid/methyl methacrylate, and ethylene/acrylic acid/n-butyl methacrylate.
30 Preferred acid-containing ethylene copolymers include ethylene/methacrylic acid/n-butyl acrylate, ethylene/ acrylic acid/n-butyl acrylate, ethylene/methacrylic acid/methyl acrylate, ethylene/acrylic acid/ethyl acrylate, ethylene/methacrylic acid/ethyl acrylate, and

ethylene/acrylic acid/ methyl acrylate copolymers. The most preferred acid-containing ethylene copolymers are, ethylene/(meth)acrylic acid/n-butyl acrylate, ethylene/(meth)acrylic acid/ethyl acrylate, and ethylene/(meth)acrylic acid/methyl acrylate copolymers.

5 Cation Source

 The acid moiety in the ethylene acid copolymer is neutralized by any cation source known in the art. Prior to the addition of sufficient high-molecular weight, monomeric organic acid or salt thereof, the ethylene acid copolymers may optionally be partially neutralized to a
10 level between about 1 and about 100% provided that the level of neutralization is such that the resulting ionomer remains melt-processible. Suitable cations include lithium*, sodium, potassium, magnesium*, calcium*, barium, lead, tin, zinc or aluminum (*= preferred), or a combination of such cations. Particularly preferred cations are selected
15 from the group consisting of alkaline earth metals.

 It has been found that, by adding sufficient high molecular weight, monomeric organic acid or salt of organic acid to the acid copolymer or ionomer, the acid copolymer or ionomer can be neutralized without losing processibility to a level above the level that would cause the
20 ionomer alone to become non-melt-processable. That is to say that neutralization of the acid moieties in the acid copolymer from which the ionomer is made can be accomplished to at least 40 to about 100%, preferably at least about 90% to about 100%, and most preferably 100%, without losing processibility. Such high neutralization, particularly to levels
25 greater than 80%, greater than 90% or greater than 95% or most preferably 100% without loss of processibility is accomplished by

- (a) melt-blending an ethylene α,β ethylenically unsaturated carboxylic acid copolymer or a melt-processable ionomer thereof with an organic acid or a salt of organic acid, and
30 (b) adding a sufficient amount of a cation source (up to 110% of the amount needed to neutralize the total acid in the copolymer or ionomer and organic acid or salt to the desired level) to increase the level of neutralization of all the acid

moities therein preferably to greater than 90%, preferably greater than 95%, or preferably to 100%. To obtain 100% neutralization, it is preferred to add a slight excess, say up to 110%, of cation source over the amount stoichiometrically required to obtain 100% neutralization.

Thermoplastic elastomer polymer components selected from group consisting of copolyetheresters, copolyetheramides, elastomeric polyolefins, styrene diene block copolymers and thermoplastic polyurethanes, fillers and other ingredients, if included, can be blended in either before, during or after the acid moieties are neutralized to more than 90% or to about 100%. Preferably, thermoplastic elastomers, along with fillers (particularly those that react with acid) and other ingredients, are blended in after neutralization to the high level (greater than 80%, greater than 90%, greater than 95%, or preferably about 100%).

Filler

Filler. The optional filler component of the subject invention is chosen to impart additional density to blends of the previously described components, the selection being dependent upon the intended use of the composition (e.g. the type of golf ball desired (i.e., one-piece, two-piece, three-piece or intermediate layer), as will be more fully detailed below). Generally, the filler will be inorganic having a density greater than about 4 gm/cc, preferably greater than 5 gm/cc, and will be present in amounts between 0 and about 60 parts per hundred parts by weight of the ionomer, organic acid and thermoplastic elastomer polymer. Examples of useful fillers include zinc oxide, barium sulfate, lead silicate and tungsten carbide, tin oxide, as well as the other well known corresponding salts and oxides thereof. It is preferred that the filler materials be non-reactive or almost non-reactive with the polymer components described above when the ionomers are less than completely neutralized. If the ionomers are fully neutralized, reactive fillers may be used. Zinc Oxide grades, such as Zinc Oxide grade XX503R available from Zinc Corporation of America, that do not react with any free acid to cause cross-linking and a drop in MI are preferred, particularly when the ionomer is not fully neutralized.

Other components

Additional optional additives useful in the practice of the subject invention include diacids such as adipic, sebacic or dodecane dioic acid or an acid copolymer wax (e.g., Allied wax AC143 believed to be an ethylene/16-18% acrylic acid copolymer with a number average molecular weight of 2,040) which assist in preventing reaction between the filler materials (such as reactive grades of ZnO) and the acid moiety in the ethylene copolymer. Other optional additives include TiO₂, which is used as a whitening agent or filler; optical brighteners; surfactants; processing aids; etc.

COMBINATIONS OF COMPONENTS

The specific combinations of components used in the practice of the subject invention will in large part be dependent upon the application. The preferred combinations for various types of golf balls (i.e., one-piece, two-piece, three-piece, or multi-layered), are as detailed below.

Three-piece golf ball preferred embodiments

As used herein, the term "three-piece ball" refers to a golf ball comprising a center, a traditional elastomeric winding wound around the center, and a cover made from any golf ball cover material such as Surlyn® ionomer resin, balata rubber or thermoset /thermoplastic polyurethanes and the like. These three-piece golf balls are manufactured by well-known techniques as described in U.S. 4,846,910 for example.

For purposes of this invention, the center of these three-piece balls is made by injection molding of the compositions of this invention. Those centers are placed in a winding machine in which the end of an elastomeric thread is affixed to the molded center and the thread is wound around the center to a predetermined thickness. A dimple-patterned cover is molded around the wound center.

The center is made of a composition comprising (a) ethylene acid copolymer, (b) 5-35 (alternatively 20 – 30, or 20 – 25) wt.% high-molecular weight, monomeric organic acid or salt thereof provided that component (b) does not exceed 50 wt.% of (a) plus (b), (c) 10-35 wt.%

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(alternatively 25-35 wt.%, preferably 28-35 wt.%) thermoplastic elastomer selected from copolyetheramides, copolyetheresters, elastomeric polyolefins, styrenic diene block copolymers or thermoplastic polyurethanes, (d) sufficient cation to neutralize 50 to 110 percent of the acid in the acid copolymer and organic acid, and (e) sufficient filler, preferably 40-60 parts per hundred parts by weight of (a) through (d) (alternatively 40-55 parts per hundred and most preferably 50-55 parts per hundred) to adjust the density of the center, preferably to about 1.8 gm/cc, so that the total golf ball weight meets specified limits. The amount of filler (and hence the density of the center) can be adjusted depending on the size, thickness and composition of the other ball components to produce a golf ball weighing about 45 – 46 grams (i.e., meet standards set by the professional golfers' governing authority).

The preferred thermoplastic elastomer component is a copolyetherester. The preferred salt of high molecular weight, monomeric organic acid is metal salt of stearic, behenic, oleic, or erucic acid. The preferred acid-containing ethylene copolymer ionomer is an ethylene/methacrylic acid/normal butyl acrylate or ethylene/acrylic acid/normal butyl acrylate terpolymer.

A particularly preferred three piece golf ball comprises a center, an elastomeric winding and a cover wherein the center comprises (a) an ethylene/acrylate ester/acrylic acid copolymer highly neutralized (>80%, >95%, or preferably 100%) with magnesium cation, (b) about 5 to about 10 wt.% magnesium salt of stearic acid, (c) about 10 to about 35 wt.% a copolyetherester having a shore D hardness of 40, (d) sufficient magnesium cation source to highly neutralize (a) and (b), and (e) sufficient ZnO to adjust the density of the composition to about 1.8 gm/cc,.

Two-piece golf ball preferred embodiments

As used herein, the term "two-piece ball" refers to a golf ball comprising a core made from the compositions of the invention, and a cover made from any traditional golf ball cover material as discussed above. These two-piece balls are manufactured by first molding the core from the compositions of the subject invention, positioning these preformed cores in an injection molding cavity using retractable pins, then

injection molding the cover material around the core. Alternatively, covers can be produced by compression molding preformed half shells of cover material over the cores.

5 The core is made of a composition comprising (a) ethylene acid copolymer, (b) 10-45 wt.% (alternatively 20-40 wt.%, preferably 25-37 wt.%) organic acid or salt thereof provided that component (b) does not exceed 50 wt.% of (a) plus (b), (c) 1-30 wt.% (alternatively 1-25 wt.%, preferably 5-20 wt.%) thermoplastic elastomer, (d) sufficient cation source to neutralize 50 to 110 percent of the acid in (a) and (b), and (e) sufficient
10 filler, preferably 15-35 parts per hundred parts by weight of (a) through (d) (preferably 18-23 parts per hundred), to adjust the density of the core, preferably to about 1.18 – 1.22 gm/cc, so that the total golf ball weight meets specified limits. The amount of filler can be adjusted to produce a core with a density varying from the 1.18 – 1.22 gm/cc range depending
15 on the diameter of the core and the thickness and composition of the cover to produce a golf ball meeting the weight limits (45.93 grams) set by the professional golfers' governing authority. Preferably the filler has a density of about 4 gm/cc or greater, more preferably about 5 gm/cc or greater.

20 The most preferred thermoplastic elastomer component is a copolyetherester. The most preferred acid-containing ethylene copolymer ionomer is an ethylene /acrylic acid/n-butyl acrylate copolymer ionomer.

The two-piece balls that perform well , as seen in the Examples below, contains a core molded from a composition that
25 comprises (a) ethylene/(meth)acrylic/n-butyl acrylate highly neutralized (>80, >95, preferably 100%) with magnesium cations, (b) 12 to 24 wt.% of the magnesium salt of organic acid, particularly a fatty acid such as stearic acid or oleic acid, (c) 10 -35 wt.% copolyetherester, (d) sufficient magnesium cation source to highly neutralize the acid in (a) and (b), and
30 (e) about 22.5 total weight percent ZnO.

A particularly preferred two-piece golf ball has a core density of about 1.18 gm/cc that comprises (a) ionomer that is a partially neutralized ethylene/alkyl (meth)acrylate/(meth)acrylic acid copolymer, (b)

salt of the organic acid that is a salt of fatty acid such as stearic or oleic acid; (c) thermoplastic elastomer polymer that is a polyetherester having a shore D hardness of about 30 - 40, (d) sufficient cation source to neutralize (a) and (b), and (e) filler that is selected from ZnO and BaSO₄.

- 5 Preferably the salt of fatty acid such as stearic or oleic acid is a magnesium salt, the ionomer is an ethylene/(meth)acrylic acid/n-butyl acrylate highly neutralized with Mg cations to form the ionomer, and the filler is ZnO.

A preferred two-piece golf ball comprises a thermoplastic
10 core has a dimple pattern such that when positioned in the ball and covered by the cover having a dimple pattern, the cover thickness in the dimple areas is the about the same as the dimple thickness in the non-dimpled areas.

One-piece golf ball preferred embodiments

- 15 As used herein, the term "one-piece ball" refers to a golf ball molded in toto from the compositions of the subject invention, i.e., not having elastomeric windings nor a cover. The one-piece molded ball will have a traditional dimple pattern and may be clear coated with urethane or be painted for appearance purposes, but such a coating and/or painting
20 will not affect the performance characteristics of the ball. These one-piece balls are manufactured by direct injection molding techniques or by compression molding techniques.

Preferably a one-piece golf ball comprises (a) ethylene acid copolymer, (b) 10-50 wt.% (alternatively 20-40 wt.%, more preferably 25-
25 37 wt.% organic acid or salt thereof provided that component (b) does not exceed 50 wt.% of (a) plus (b), (c) 1-30 wt.% (alternatively 1-25 wt.%, more preferably 5-20 wt.%) thermoplastic elastomer, (d) sufficient cation source to neutralize 50 to 110% of the acid in (a) and (b), and (e) sufficient filler, preferably 15-25 parts per hundred parts by weight of (a)
30 through (d) (more preferably 18-22 parts per hundred), to adjust density of ball to 1.14 grams/cubic centimeter (gm/cc) or to a density that results in a golf ball that does not exceed the limitation on weight of golf ball set by the professional golfers' governing authority (USGA – 45.93 grams).

Preferably the filler has a density of about 4 gm/cc or greater, more

preferably 5 gm/cc or greater. Density for larger balls (for example, 1.715 inches, 4.3561 cm) will be lower than the 1.14 gms/cc needed to produce a 45.93 gram standard size ball (1.68 inches, 4.2672 cm.). For larger balls, density can be as low as 1.05 gms/cc, for example. Also, the amount of filler may be adjusted to yield a density of less than 1 gm/cc if balls that float in water are desired.

Again, the most preferred thermoplastic elastomer component is a copolyetherester. The most preferred metal salt of an organic acid is magnesium stearate, magnesium oleate, magnesium laurate or magnesium salt of erucic acid. The most preferred acid-containing ethylene copolymer ionomer is an ethylene/acrylic acid/n-butyl acrylate copolymer almost totally neutralized with magnesium cations.

The one-piece balls that perform well, as seen in the Examples below, are molded from compositions of the subject invention comprising (a) 29.5-50 wt.% ethylene/acrylic acid/n-butyl acrylate copolymer highly neutralized (>80%, >90%, >95%, or preferably 100% with Mg cations to form the ionomer, (b) 8.5-27 wt.% metal salt of organic acid based on (a), (b) and (c) provided that component (b) does not exceed 50 wt.% of (a) plus (b), (c) about 5-35 wt.% of copolyetherester, (d) sufficient magnesium source to highly neutralize (a) and (b), and (e) about 15 - 24 wt.% ZnO as filler.

A particularly preferred one-piece ball is one having (a) ethylene/(meth)acrylic/n-butyl acrylate highly neutralized with Mg cations, (b) about 5 to about 40 wt.% magnesium salt of fatty acid such as stearic or oleic acid provided that component (b) does not exceed 50 wt.% of (a) plus (b), (c) 1 to about 35 wt.% polyetherester having a shore D hardness of about 30 – 40, (d) sufficient magnesium cation source to highly neutralize (a) and (b), and (e) sufficient zinc oxide in an amount up to 60 parts per hundred parts by weight of (a) through (d) to adjust the density of the composition in a range of from about 1.14 to about 1.8 gm/cc to result in a golf ball meeting the weight limits set by the professional golfers' governing authority.

Multi-Layer golf ball preferred embodiments

As used herein, the term "multi-layer ball" refers to a golf ball comprising a core (sometimes referred to as a center), a cover made from any traditional golf ball cover material as discussed above, and one or more mantles between the core and the cover. These multi-layer balls are manufactured by first molding or making the core, typically compression or injection molding a mantle over the core and then compression or injection molding a cover over the mantle.

The multi-layer golf ball having a core and a cover with one or more intermediate layers or mantles between the core and the cover. Both the core and the mantle(s) can comprise the composition of this invention. The amount of filler employed in the core and mantle(s) can be varied from 0 to about 60 parts per hundred parts by weight depending on the size (thickness) of the components and the desired location of the weight in the ball, provided that the final ball meets the required weight limits set by professional golfers' governing authority (45-46 grams). The filler can be used in the core and not in the mantle, in the mantle and not in the core, or in both. Thus, the mantle or the core can comprise (a) ethylene acid copolymer, (b) 5-45 wt.% salt of organic acid provided that component (b) does not exceed 50 wt.% of (a) plus (b), (c) about 1-35 wt.% thermoplastic elastomer, (d) sufficient cation source to neutralize 50 to 110 (preferably >80%, >90%, >95% or 100%) of the total acid in (a) and (b), and (e) sufficient filler to adjust the density to the desired level. While not intending to be limiting as to possible combinations, this embodiment includes:

1. a core comprising the same composition used in the three-piece center with a mantle made of any composition known in the art,
2. a core comprising the same composition used in the two-piece core or three-piece center with a mantle made of the composition of this invention with or without filler (acid copolymer, 5-45 wt.% salt of organic acid provided that the organic acid does not exceed 50 wt.% of acid copolymer plus organic acid, 1-35 wt.% thermoplastic elastomer, sufficient cation source, and up to 60 parts per hundred parts by weight filler (preferably up to 35 parts per hundred)), the total filler in

core and mantle adjusted to provide a golf ball of the desired weight,
and

3. a core made of any composition (including thermoset compositions
such as polybutadiene rubber) with a mantle made of the composition
of this invention with or without filler provided that the weight of the
finished golf ball meets the required limit.

TESTING CRITERIA

In the Examples set out below, a number of testing criteria
are utilized in the evaluation of golf ball performance (e.g., percent
rebound, coefficient of restitution (COR) and compression).

Percent rebound is determined by dropping the ball or
sphere (e.g., three-piece center or two-piece core) from a height of 100
inches (254 cm) and measuring the rebound from a hard, rigid surface
such as a thick steel plate or a stone block. An acceptable result is about
65-85%.

COR is measured by firing a golf ball or sphere (e.g., three-
piece center or two-piece core) from an air cannon at a velocity
determined by the air pressure. The initial velocity generally employed is
between 125 to 180 feet/second (38.1-54.86 m/sec). The ball strikes a
steel plate positioned three feet away from the point where initial velocity
is determined, and rebounds through a speed-monitoring device. The
return velocity divided by the initial velocity is the COR. Acceptable results
are 0.700 – 0.810 at 125 ft/sec (38.1 m/sec). Still higher COR's are
preferred.

Compression is defined as the resistance to deformation of a
golf ball, measured using an Atti machine. An acceptable result is about
70-120.

Initial Velocity, reported in feet/second and measured using
a Wilson Initial Velocity Test Machine, is the initial velocity of the ball as it
leaves the Test Machine.

Durability is the number of hits to failure of a ball that is fired
into a steel plate at 175 feet/second. Test is stopped at 100 hits.

Numbers in parentheses in the tables represent the weight
percentage of the component in the blend, unless otherwise indicated.

TWO PIECE GOLF BALLS PRODUCED WITH THERMOPLASTIC CORES

These examples describe the preparation of blends for the core for two piece golf balls, golf balls made therefrom, and the properties of the cores and finished balls. The composition of these blends is shown in Table 2. The blends were made using extrusion conditions shown in Table 1A. The blends were molded into cores using conditions shown in Table 1B. The core is 1.53 inches (3.89 cm) in diameter. Balls were prepared by positioning preformed thermoplastic cores in an injection molding cavity. The cores were centrally positioned in the cavity by the use of retractable pins. A cover of mixed Surlyn® ionomer resin was then injection molded around the core. Properties of the resultant cores or balls are shown in Tables 2A and 2B.

TABLE 1A EXTRUSION CONDITIONS FOR TWO PIECE CORES

Screw Speed Rpm	Zone 1 temp °C	Zone 2 temp °C	Zone 3 temp °C	die temp °C	Rate lb./hr.	Vacuum inches
100-300	150-170	175-190	200-220	200-230	15-25 (6.8-11.34 Kg/hr)	28 (6.9 kPa)

TABLE 1B MOLDING CONDITIONS FOR TWO-PIECE CORES

	Temp. °C
Rear	162
Center	176
Front	176
Nozzle	177
Mold Front/Back	21/21
Melt	199

Pressures Kg/cm²

Injection 1 st Stage	86
Injection 2 nd Stage	82
Injection 3 rd Stage	47

Cycle Times (sec)

Hold in 1 st Stage	10
-------------------------------	----

Hold in 2 st Stage	40
Hold in 3 st Stage	50
Cure Time	20
Screw Retraction	3.5

Screw Speed 150 RPM
Back Pressure 19 Kg/square cm.
Mold Diameter 4.01 cm

- 5 *Prototype mold, limited cooling, two cavity

TABLE 2 CORE COMPOSITIONS

Ex No.	Thermoplastic	Metal salt	Ionomer	Filler
1	H1 (15)	J (20)	B (47)	F3 (18)
2	H1 (10)	J (24)	B (48)	F3 (18)
3	H1 (15)	J (22)	B (45)	F3 (18)

(Percentages given in parenthesis)

- B Ethylene , 17 % normal butyl acrylate, 12 % acrylic acid 60 %
 neutralized with magnesium ions
- H1 Hytrel®3078 polyetherester block copolymer available from
 E. I. du Pont de Nemours and Company
- F3 Zinc Oxide, grade XX503R available from
 Zinc Corporation of America.
- J Magnesium stearate available from Witco Corporation

TABLE 2A PROPERTIES of THERMOPLASTIC CORES

Ex No.	M.I. (g/10min)	Atti Compression	Drop Rbn. %	COR @ 125 ft/sec (38.1 m/sec)
1	0.53	99	77	0.769
2	0.38	102	78.2	0.778
3	0.50	97	78.1	0.777

TABLE 2B 2-PC. BALL PROPERTIES MADE FROM CORES IN TABLE 2A

Core	Cover	Weight grams	Atti Compression	COR @ 125ft/sec (38.1 m/sec)
1	X	44.5	112	0.799
2	X	43.9	114	0.806
3	X	44.1	113	0.808
Control*	X	45.2	108	0.789

X - 50/50 blend of ethylene/19% methacrylic acid zinc ionomer about 36% neutralized and ethylene/19% methacrylic acid sodium ionomer 49% neutralized.

*The control ball core is a Wilson Ultra polybutadiene core.

It can be seen from data that thermoplastic cores give golf balls with a higher resilience then ball produced from the thermoset core.

Examples of One-Piece Golf Balls

Thermoplastic blends of the materials in Table 4 were, in general, melt homogenized using a 3 inch (7.62 cm) electrically heated roll mill. The blends in Examples 5d and 5h were produced by neutralizing the acid copolymer with magnesium 2,4 pentanedionate on a roll mill followed by the addition of the other ingredients. The resulting blends compression molded into one-piece balls had the properties shown in Table 4A.

TABLE 4 ONE PIECE BALL COMPOSITIONS

Ex No	Thermoplastic	Ionomer	Metal salt	Filler
4a	H1(5)	B(50)	J(27)	F3 (18)
4b	H1(20)	B(44.5)	J(17.5)	F3 (18)
4c	H1(35)	B(29.5)	J(17.5)	F3 (18)
4d	H1(15)	B(47)	J(20)	F3 (18)
4e	H1(15)	B(47)	K(20)	F3 (18)
4f	H1(15)	B(47)	L(20)	F3 (18)
4g	H1(15)	B(47)	M(20)	F3 (18)
4h	H1(15)	B(47)	N(20)	F3 (18)
4i	H1(15)	B(47)	O(20)	F3 (18)
5a	H1(15)	B(47)	P(20)	F3 (18)
5b	H1(15)	B(58.5)	Q(8.5)	F3 (18)
5c	H1(15)	B(50)	Q(17)	F3 (18)
5d	H1(15)	C(47)	J(20)	F3 (18)
5e	G(15)	B(47)	J(20)	F3 (18)
5f	H1(15)	B(47)	R(20)	F3 (18)
5g	H1(15)	B(47)	S(20)	F3 (18)
5h	H1(15)	B(47)	J(20)	F3 (18)

Ingredients not previously identified are as follows:

- C. Ethylene/20% ethyl acrylate/5% acrylic acid neutralized 60% with Mg.
- G. Pebax®3533 which is a polyetheramide available from Elf ATO.
- 5 K - magnesium salt of behenic acid prepared by reacting magnesium acetate with behenic acid in an excess of acetic acid under reflux conditions, followed by removing the acetic acid by evaporation.
- L - magnesium salt of oleic acid produced in a manner similar to that for K
- M - sodium salt of Hoechst Wax S (a C₃₆ saturated wax extracted from
- 10 brown coal).
- N - calcium salt of Hoechst Wax S
- O - lithium salt of Hoechst Wax S
- P - magnesium salt of Hoechst Wax made from Hoechst S in the same manner as the other commercially unavailable salts (see K).
- 15 Q - magnesium salt of dodecanedioic acid made from the acid in manner similar to that for K.

R - magnesium salt of erucic acid made in a manner similar to that for K
 S - magnesium salt of lauric acid prepared in a manner similar to that of K

TABLE 4A - PROPERTIES OF ONE PIECE BALLS

Ex No	Atti Compression	COR @ 125 ft/ sec. (38.1 m/sec)
4a	89	0.781
4b	77	0.764
4c	65	0.767
4d	79	0.771
4e	81	0.749
4f	69	0.763
4g	108	0.733
4h	108	0.725
4i	108	0.703
5a	102	0.705
5b	85	0.675
5c	101	0.662
5d	51	0.731
5e	72	0.772
5f	52	0.769
5g	76	0.782
5h	56	0.772

5

**ECHIP DESIGNED EXPERIMENT TO OPTIMIZE COR AND ATTI
 COMPRESSION**

Employing an “experimental design” protocol known as
 ECHIP®, a copyrighted product of Echip Inc., an experimental design was
 used to evaluate the effects of and interactions between magnesium
 stearate concentration, ionomer concentration and copolyetherester
 concentration to determine the effect on compression and coefficient of
 restitution for one-piece compression-molded golf balls of the three-
 component blend plus 18 wt.% ZnO to adjust density.

10

From the results displayed in Figures 1, 2, 3 and 4, compositions that exhibit preferred compression and coefficient of restitution can be predicted.

TABLE 5

Ex No.	% Hytrel	% Mg	%	Atti	COR
	H1	Stearate J	Ionomer*	comp.	
6a	35	30%	17	79	0.738
6b	5	5	72	80	0.718
6c	20	17.5	44.5	77	0.770
6d	20	30	32	86	0.770
6e	35	5	42	53	0.716
6f	5	17.5	59.5	86	0.771
6g	35	17.5	29.5	62	0.758
6h	5	30	47	86	0.792
7a	20	5	57	68	0.703
7b	5	5	72	81	0.716
7c	35	30	17	75	0.746
7d	20	17.5	44.5	74	0.762
7e	35	5	42	48	0.718
7f	5	30	47	83	0.789

- 5 Note: All samples contain 18% F3 as the zinc oxide filler to adjust for density.

*E/12AA/17nBA neutralized to 60 % level with Mg cations.

RETENTION OF COMPRESSION AND COR VALUES ON ANNEALING SAMPLES

- 10 Table 6A shows the results of annealing one piece golf ball formulations at 60°C for 48 hours. These results indicate that, unlike the ion-synergy observed in cover materials, the addition of a metal salt of an organic acid performs better if the ion in the organic acid and the ion in the ionomer are the same.

TABLE 6

Identification	Thermoplastic	Mg Stearate	Ionomer %
8a	H1 (18)	20	B-1(44)
8b	H1 (20)	20	B-1(42)
9a	H1 (15)	20	B (47)
9b	H1 (10)	21	B (50)
9c	H1 (10)	24	B (48)

B-1 is the lithium ionomer produced from E/12AA/17nBA neutralized to 60 % level.

TABLE 6A

Ident	Before Annealing		After Annealing		Delta Comp.	Delta COR
	Atti Comp.	COR @ 125 ft/sec	Atti Comp.	COR @ 125 ft/sec		
		(38.1 m/sec)		(38.1 m/sec)		
8a	118	0.739	111	0.692	- 7	-.047
8b	115	0.743	110	0.705	- 5	-.038
9a	72	0.782	67	0.776	- 5	-.006
9b	72	0.787	69	0.780	- 3	-.007
9c	79	0.788	73	0.785	- 6	-.003

CO-NEUTRALIZATION OF FATTY ACIDS AND ETHYLENE ACID COPOLYMERS

Neutralization of acid copolymers and fatty acids at the same time is advantageous as the materials can be neutralized to about 100% neutralization without losing the melt processibility associated with ionomers neutralized to greater than 90%. In addition, neutralizing to 100% reduces the deposits of the fatty acids on the mold vent observed upon molding mixtures with less than 100% neutralization.

Using a Werner & Pfleiderer twin screw extruder it was possible to neutralize the acid copolymer and the stearic acid (or any other fatty acid) at the same time. Hence, 4812 grams of stearic acid were added to 7218 grams of an E/23nBA/9.6MAA polymer. Enough

magnesium hydroxide (656.3 grams) was added to this mixture to neutralize 70 % of the available acid. The resulting ionomer/fatty acid salt blend had a melt index of 9.0 grams per 10 min (see Ex 10a table 7). Additionally, similar materials with 90 and > 95 % neutralization were prepared in a similar manner (see Ex 10b & 10c)

Two other resins with the composition cited in Table 7 were reacted with stearic acid and magnesium hydroxide. However, in this case, enough magnesium hydroxide was added to neutralize more than 100% of the available combined acids thus assuring complete neutralization. These mixed anionic ionomers Ex 11a and 11b are listed in Table 7.

Still other resins with the composition cited in Table 7 were reacted with a different level of stearic acid (Ex 12) or with different fatty (oleic) acid (Ex 13 and 14) and enough magnesium hydroxide to neutralize more than 100% of the total available acid to obtain mixed anionic ionomers as indicated.

TABLE 7 MAGNESIUM HIGH-MOLECULAR WEIGHT, MONOMERIC ORGANIC ACID MODIFIED MAGNESIUM IONOMERS

Ex No	Resin Comp.	Cation Type	Organic Acid (%)	% Neut	M.I.
10a	E/23nBA/9.6MAA	Mg	Stearic(40)	70	9
10b	E/23nBA/9.6MAA	Mg	Stearic(40)	90	5.2
10c	E/23nBA/9.6MAA	Mg	Stearic(40)	95	3.6
11a	E/15nBA/8.5AA	Mg	Stearic(40)	>100	1.15
11b	E/16nBA/12AA	Mg	Stearic(40)	>100	0.09
12	E/15nBA/8.3AA	Mg	Stearic(34)	>100	.5 - .9
13	E/15nBA/8.3AA	Mg	Oleic(34)	>100	.5 - .9
14	E/12.5AA	Mg	Oleic (40)	>100	.5 - .9

Fifty five weight percent of each mixed anionic ionomer in examples 10 a, b, and c, and in examples 11 a and b was salt and pepper blended with 45 weight percent of a Hytrel®3078/zinc oxide concentrate containing 50 % zinc oxide. Using a mixing screw on a 6 ounce injection molding machine, spheres 1.524 to 1.531 inches (3.87-3.89 cm) in diameter were molded using the conditions cited in Table 1B. Cores were

evaluated for Atti compression and for COR. Table 8 and 8A show the results of these evaluations.

TABLE 8 TWO PIECE CORES PRODUCED FROM SALT and PEPPER BLENDS of IONOMERS 10a-c and POLYETHERESTERS

Ex No	Ionomer/ stearate	Hytrel®/ZnO Concentrate	M.I. of blend	COR @ 125 ft/sec (38.1 m/sec)	Atti Comp.	Density
10aa	10a(55%)	45%	1.95	0.752	103	1.16
10bb	10b(55%)	45%	1.89	0.758	92	1.2
10cc	10c(55%)	45%	1.49	0.759	98	1.18

5 Table 8A shows the results of cores made in the same fashion from the ionomer/stearate blends 11a and 11b.

Table 8A CORES PRODUCED FROM SALT AND PEPPER BLENDS of IONOMERS 11a & 11b and POLYETHERESTERS

Ex No.	Ionomer/ stearate	Hytrel®/ ZnO Concentrate	COR @125 ft/sec (38.1 m/sec)	Atti Comp.	Density
11aa	11a(55%)	45%	0.768	110	1.18
11bb	11b(55%)	45%	0.782	108	1.19

10 Employing the molding conditions set forth in Table 9A, golf ball cores 12-a, 12-b, 12-c, and 13 were produced by injection molding. Salt and pepper blends of the Ionomer/Stearate in the case of 12a, 12b and 12c (or Ionomer/Oleate in the case of 13), the Hytrel®/ZnO Concentrate of 30 wt.% H1 and 70 wt.% F3, and additional Hytrel®

15 polyetherester (H1) in percentages set for in Table 9 were injection molded into spheres of 1.5075 – 1.5168 inches in diameter. The spheres were tested for Atti Compression, Shore D hardness, and COR @ 125 feet/sec. Results are reported in Table 9B. Also reported for comparison with 12a, 12b, and 12 c is Thermoset Control A (a standard Wilson Ultra

20 Core) believed to be crosslinked polybutadiene, and for comparison with 13 is Thermoset Control B (a Wilson Hyper Ti Max Distance Core) believed to be crosslinked polybutadiene with a lower Atti compression than Thermoset Control A.

TABLE 9 CORES PRODUCED FROM SALT AND PEPPER BLENDS OF RESINS 12 (IONOMER/STEARATE) and 13 (IONOMER/OLEATE) and POLYETHERESTERS

Ex No	Cores	Ionomer/ stearate	Hytrel®/ZnO Concentrate H1(30%)/F3(70%)	H1
12aa	12a	12(41.01)	25.68	33.31
12bb	12b	12(53.22)	28.82	17.82
12cc	12c	12(66.39)	32.21	1.4
		Ionomer/ oleate		
13	13a	13 (54.6)	25.9	19.5

5

TABLE 9A MOLDING CONDITIONS FOR TWO-PIECE CORES

	Temperature °C
Rear	177
Center	190
Front	190
Nozzle	190
Mold	205
	Pressure (psig)
Peak Injection Pressure	2300
Pack Pressure	1100
	Time (sec.)
Injection Time	10-12
Pack Time	30
Cooling Time	120

TABLE 9 B

Core	Atti compression	Shore D hardness	COR @125 ft/sec
12a	62.2	45	0.775
12b	77.1	48	0.789
12c	91.1	50	0.796
Thermoset Control A	80.3	58	0.791
13a	69.4		0.796
Thermoset Control B	60.5		0.791

Two-piece golf balls employing the cores from Table 9 B were made using a Newbury 75 ton injection molding machine equipped

with a four-cavity mold having ball cavity diameters of 1.694 inches. The cores were placed in the mold and centered with pins, the mold was closed, the cover materials were injected over the cores, pins were pulled, and balls removed. Operating conditions were as follows:

<u>Times and Pressures</u>	<u>Temperatures °C</u>
Pack time: 5.00 seconds	Front 227
Injection time: 1.00 seconds	Barrel 227
Total cycle time: 40 seconds	Rear 191
Cushion: 0.25 inches	Mold 7.2
Feed stroke: 3.5 inches	
Peak pressure: 1500 psi	
2 nd stage hold pressure: 550 psi	
Back pressure: 200 psi	

5

The resulting two-piece balls were tested for Atti compression, COR at 125 ft./sec., initial velocity in ft./sec. And durability (results are reported in Table 9 C). COR's for examples 12 – 14 were run on a different COR machine than others in this case. Results should be compared only with internal controls associated with the examples.

10

**TABLE 9 C TWO PIECE GOLF BALLS PRODUCED FROM
THERMOPLASTIC CORES 12 A, 12 B, 12 C, and 13 A**

CORE NO (COVER TYPE)	Atti compression	COR @125 ft/sec	Initial Velocity Ft/sec	Durability No. of hits to break
12a (WW)	89.7	0.800	255.9	43.3
12b (WW)	99.7	0.804	255.7	64.7
12c (WW)	108.7	0.806	255	99.8
CONT A (WW)	102.4	0.816	257	49
12a (XX)	86.3	0.790	255.2	31.8
12b (XX)	94.2	0.801	255.6	76.8
12c (XX)	106.4	0.801	254.9	99.0
CONT A (XX)	101.3	0.808	257	57.6
12a (YY)	78.3	0.772	252.0	84.3
12b (YY)	86.8	0.782	252.9	99
12c (YY)	98.4	0.798	252.8	100
CONT A (YY)	89.1	0.790	253.5	66.2
13a (YY)	72	0.799	254	
CONT B (YY)	66	0.792	253.6	
13a (ZZ)	88	0.822	257	
CONT B (ZZ)	87	0.822	257	
13a (aa)	71	0.811	256.2	
CONT B (aa)	68	0.811	255.1	

Cover compositions: WW= 50/50 Blend of RR/SS – Shore D 71 (on ball);

XX = 50/50 Blend of Surlyn®8940 (E/15% MAA, 29% Na Neutralized)/

5 Surlyn®9910 (E/15%MAA, 58% Zn neutralized – Shore D 66 (on ball);

YY = 35/65 Blend of RR/GG – Shore D 57 (on ball);

ZZ = 60/40 Blend of RR/SS – Shore D 71 (on ball);

aa = 30/70 Blend of Resin 14/Resin 13.

EXAMPLE 14 - MULTI-LAYERED SOLID GOLF BALLS WITH MODIFIED IONOMER MANTLES

The multi-layer golf balls of this set of examples are made by methods known in the art, for example, in U.S. Patents 5,314,187, dated May 24, 1994, and 5,255,922, dated October 26, 1993.

In particular, the golf balls in this set of examples were produced by injection molding a mantle with a thickness of 0.025 to 0.030 inches over solid polybutadiene centers with a diameter of 1.52 inches (see formulation 222) using the conditions in Table 10. These two-piece cores (center plus mantle) were subsequently covered with a mixed thermoset polyisoprene/ polybutadiene thermoset cover (see formulation 333). The resulting balls were compared with ball having a standard mixed ionomer mantle.

FORMULATION 222 CENTERS FOR MULTI LAYERED BALLS

	PARTS
Enichem BR – 40 Polybutadiene	100
SR-416 Zinc Diacrylate	20
Zinc Stearate	3
Zinc Oxide	5
Barytes	30
Triganox 29/40 peroxide	1.25

TABLE 10 - CONDITIONS TO MOLD MANTLES OVER THERMOSET CENTERS

	Temperature °C
Rear	191
Center	243
Front	243
Nozzle	243
Mold	7.2
	Pressure (psig)
Peak Injection Pressure	2300
Pack Pressure	700
	Time (sec.)
Injection Time	4
Pack Time	30
Cooling Time	42

The thermoset centers were placed in a mold, centered by pins, the mold was closed, the thermoplastic materials were injected into the cavities, the pins were retracted and the multilayered cores were removed and covered with the materials identified as below as

- 5 Formulation 333 by compression molding half shells over the cores. These balls were evaluated for Atti compression, COR and initial velocity (see Table 12)

FORMULATION 333 COVERS FOR MULTILAYERED BALLS

	Parts by weight
TP-301 Trans-Polyisoprene	60
Budene 1207 Polybutadiene	40
SR416D Zinc Diacrylate	35
Titanium dioxide	17.15
Zinc Stearate	1.57
Zinc Oxide	3.3
Varox 230XL peroxide	2.5
Wingstay L-HLS antioxidant	0.2

10 TABLE 11 MANTLES FOR MULTI LAYERED BALLS

MANTLE	IONOMER/STEARATE NO. 12	HYTREL®3078 (H1)
Mantle A	66.67%	33.33%
Mantle B	80%	20%
Mantle C	86%	14%
Control	60% RR	40% SS

TABLE 12 MULTI LAYERED BALLS

Center	Mantle	Atti Comp.	COR @ 125	I.V.
Form. 222	A	61.5	0.798	255.5
Form 222	B	68	0.804	256.1
Form. 222	C	68.8	0.800	256.3
Control*		59	0.786	252.6

*Wilson Smart Core Balata Distance Ball with a 60/40 blend of RR/SS as mantle, Form. 333 as cover, and a core believed to be similar in composition to Form. 222.

5 As can be seen form the data in Table 12, the present invention provides an improvement in COR and IV without a significant gain in Atti compression. Spin data also looks good on these balls.

BLENDS OF FATTY ACID SALTS AND IONOMERS WITH
ALTERNATIVE SOFT RESILIENT THERMOPLASTIC ELASTOMERS.

10 The polyetherester thermoplastic elastomer cited in Examples 1 through 14 can be replaced with a number of alternative soft resilient thermoplastic elastomers. In Examples 15aa through 16bb, we the see the results of the use of such blends in cores. All of the blends cited in Tables 13A and 13B were produced by extrusion compounding
15 followed by injection molding. Parenthetical numbers are the weight percent of component in final blend. Conditions cited in Tables 1A and 1B were used to extrusion compound and injection mold for these examples.

**TABLE 13A BLENDS OF IONOMERS , FATTY ACID SALTS AND
ALTERNATIVE THERMOPLASTIC ELASTOMERS.**

Ex No	Ionomer	Fatty acid salt	Elastomer	Process Aid	Filler
Control	AA(76.3)	none	None	FF(6.1)	F3(13.8)/EE(3.8)
15-a	AA(55.3)	BB(8.3)	CC(19.3)	FF(4.4)	F3(9.9)/EE(2.8)
16-a	GG(46.3)	BB(19.9)	CC(20.8)	II (0.5)	F3(10.2)/EE(2.3)
16-b	GG(41.4)/HH(13.8)	BB(8.3)	CC(19.3)	FF(4.4)	F3(10)/EE(2.8)
17-a	GG(47.2)	BB(20.6)	JJ(8.3)	None	F3(23.9)
17-b	GG(47.2)	BB(20.6)	KK(8.3)	None	F3(23.9)
17-c	GG(47.2)	BB(20.6)	H1(8.3)	None	F3(23.9)
17-d	GG(47.2)	BB(20.6)	MM(8.3)	None	F3(23.9)
17-e	GG(47.2)	BB(20.6)	NN(8.3)	None	F3(23.9)
Control	GG(84.1)	none	None	None	F3(12.95)/ EE(2.95)
18-a	GG(50.0)	OO(21.5)	PP(15)	None	F3(11.0)/EE(2.5)
18-b	GG(41.2)	OO(17.7)	PP(30)	None	F3(9.0)/EE(2.1)
19-a	GG(19.8)/QQ(23)	OO(18.4)	TT(23)	None	F3(15.8)
Control	GG(29.4)/RR(29.4)	OO(25.3)	None	None	F3(15.9)
19-b	GG(19.8)/RR(23)	OO(18.4)	TT(23)	None	F3(15.8)
19-c	GG(20)/RR(20)	OO(17.3)	TT(26.7)	None	F3(16)
20-a	GG(20)/SS(24)	OO(16)	TT(16)/ UU(5)	None	F3(19)
20-b	GG(20)/QQ(23)	OO(16)	TT(23)	None	F3(18)

5

Ingredients not previously identified are as follows:

AA - E/23nBA/9.6 MAA neutralized to about 50 % with zinc cations available from E. I. du Pont de Nemours and Company as Surlyn®9320

BB - Calcium salt of stearic acid available from Witco Co.

10

CC - Nordel®2470 EPDM based on 70% ethylene, 24% propylene, 5.95% 1,4- hexadiene and < .05% norbornadiene available from DuPont Dow Elastomers LLC.

EE - Titanium dioxide R960 available from E. I. du Pont de Nemours and Company

15

FF- Acid-containing ethylene copolymer wax consisting of 85% ethylene and 15% acrylic acid available from Allied Signal as AC143 wax

GG- E/23 nBA/9.6MAA neutralized to about 50% with magnesium cations available from E. I. du Pont de Nemours and Company as Surlyn®6320.

HH- Ethylene copolymer ionomer containing 85% ethylene and 15 % methacrylic acid neutralized about 56% with sodium cations and available from E. I. du Pont de Nemours and Company as Surlyn®8945

II - Adipic acid

JJ Engage®8180 grafted with 2% maleic anhydride and available from DuPont of Canada as Fusabond®493D

KK Nordel®IXP3745P grafted with 1.8% maleic anhydride available from DuPont of Canada as Fusabond®503D5

MM - An ethylene octene copolymer containing 40% octene produced with metallocene polymerization catalyst with a 0.5 melt index and a density of 0.863 g/cc. available from the DuPont Dow Elastomers LLC as Engage®8180

NN - EPDM elastomer containing 69% ethylene 30.5% propylene 0.5% norbornadiene. produced with a metallocene catalyst and available from DuPont Dow Elastomers LLC as Nordel®IPX3745P

OO - Magnesium Stearate available from Witco Co.

PP - Maleic anhydride grafted block ABA styrene ethylene butene copolymer available from Shell Chemicals and sold as Kraton®G1901.

QQ - Ethylene methacrylic acid copolymer containing 15% methacrylic acid neutralized about 55% with magnesium ions to an MI of 0.9, available from E. I. du Pont de Nemours and Company as Surlyn®6910.

RR - Ethylene acid copolymer containing 19 % methacrylic acid neutralized 37% with sodium ions, available from E. I. du Pont de Nemours and Company as Surlyn®8140.

SS - Ethylene acid copolymer containing copolymer containing 19% methacrylic acid 40% neutralized with magnesium ions to an MI of

1.1, available from E. I. du Pont de Nemours and Company as Surlyn®6120.

TT - EPDM elastomer containing 71% ethylene 28.5% propylene, 0.5% norbornene produced with a metallocene catalyst and available from DuPont Dow Elastomer LLC as Nordel®IPX3720P.

UU - Maleic anhydride grafted copolymer containing 0.9% maleic anhydride grafted on to an ethylene copolymer containing 30% propylene available from DuPont of Canada as Fusabond®MF416D

TABLE 13B RESULTS ON SPHERES MOLDED FROM COMPOSITIONS CITED IN TABLE 13A

Ex No	Atti comp,	COR @125 ft/sec (38.1 m/sec)
Control	81	0.629
15-a	83	0.709
16-a	73	0.725
16-b	91	0.715
17-a	126	0.736
17-b	119	0.738
17-c	129	0.741
17-d	124	0.741
17-e	123	0.742
Control	72	0.669
18-a	67	0.740
18-b	54	0.700
19-a	95	0.735
Control	140	0.743
19-b	119	0.738
19-c	108	0.719
20-a	61	0.731
20-b	95	0.735